

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026355**Date Inspected:** 04-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

NDT

Bay 14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08735.

Ultrasonic Testing (UT)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG. The weld designations reviewed is as follows:

TR3004-001-014, 015, 003, 005

TR3003TR1-001-014, 015, 003, 005

WELDING

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

OBG Bay 14

This QA Inspector randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3013V-337 located on floor beam of the OBG Segment 13AW. The welder is identified as 201215. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3020F-017 located on deck panel diaphragm to floor beam flange of the OBG Segment 14W. The welder is identified as 066673. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3020G-002 located on deck panel diaphragm to floor beam flange of the OBG Segment 14W. The welder is identified as 067611. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3020H-011 located on deck panel diaphragm to floor beam flange of the OBG Segment 14W. The welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as TR3027TR1-001-003 located on traveler rail. The welder is identified as 062708. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as TR3002TR1-001-010 located on traveler rail. The welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3126A-001-130 located on deck panel I-rib of the OBG Segment 13BW. The welder is identified as 067588. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

DP3127A-001-023 located on deck panel I-rib of the OBG Segment 13BW. The welder is identified as 066179. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

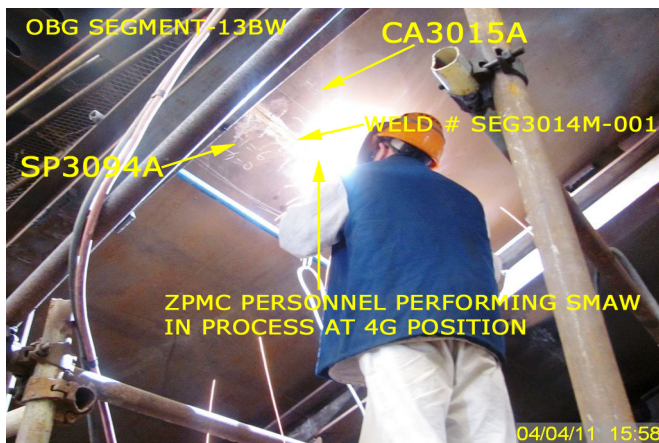
This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020BB-074 located on anchor plate to SA of the OBG Segment 14W. The welder is identified as 066261. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020G-059 located on longitudinal diaphragm stiffener of the OBG Segment 14W. The welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020G-061 located on longitudinal diaphragm stiffener of the OBG Segment 14W. The welder is identified as 067829. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3014M-001 located on side plate to corner assembly of the OBG Segment 13BW. The welder is identified as 067904. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair and B-CWR2914. For more details please see attached photo below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Singh,Vikram	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
